

SPC IT

Dart Aerospace Ltd.

Date: Friday, 5/25/2007 8:36:33 AM
User: Kim Johnston

Process Sheet

POSITIVE RECALL

EFFECTIVE 07.06.05 AUTH GP
RELEASED 07.06.06 DATE GP

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32643
Estimate Number : 12578
P.O. Number :
This Issue : 5/25/2007 S.O. No. :
Prsht Rev. : NC
First Issue : 1/1 Type : SMALL /MED FAB
Previous Run : 31443
Written By :
Checked & Approved By : 07.05.25
Comment : Est Rev: A New Issue 07.05.24 EC

Drawing Name : ARM
Part Number : D3560041
Drawing Number : D3560 REV.B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 6/5/2007

Qty: 10 30 Unit: Each

Additional Product

Job Number: 

Seq. #: Machine Or Operation: Description:

1.0 M6061T690500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.4648 f(s)/Unit Total: 43.9425 f(s)

6061-T6 Bar 0.50" x 5.00"

Batch: M17625

SA 07.05.30

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 16.750" long

SA 07.05.32

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: B

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Debur per dwg D3560

SA

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SA

07.06.06

GP

B28600

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07.06.06	11	DO NOT POWDER COAT PART. CHEM CONVERSION COAT ONLY. PART WILL BE FINISHED AFTER ASSEMBLY WITH STEP REF ATTACHED DS EMAIL.				UP 07.06.06 per QSI 042	07.06.12	
07.06.06	11	Press fit Qty 1 D2808 Bushing B 32752 qty 2 B 28600 qty 3						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07.06.12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/06	3	-2 parts are scrapped hole $\phi .507^{+0.000}_{-.001}$ are oversize by too much $\phi 0.510$ & $\phi 0.513$	QSI 042	- Destroy & Replace	JL 07/06/06	07.06.06	QSI 042	07.06.06

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:36:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32643

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)

PLATE

332641

FF 07-06-06 (5)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

FF 07-06-07 (5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

270607

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

27/06/07 (5)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 07-06-07 5

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

NO POWDER COAT
SEE WYO CHANGE



Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

27/06/07 (5)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

27/06/07 (5)

Date: Friday, 5/25/2007 8:36:34 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32643

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

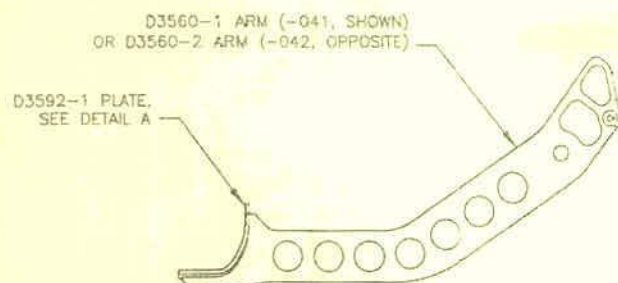


POSITIVE RECALL

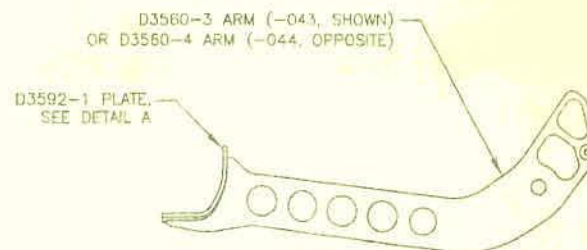
EFFECTIVE AUTH

RELEASED u DATE 07/06/12

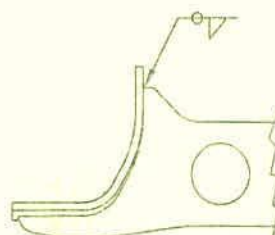
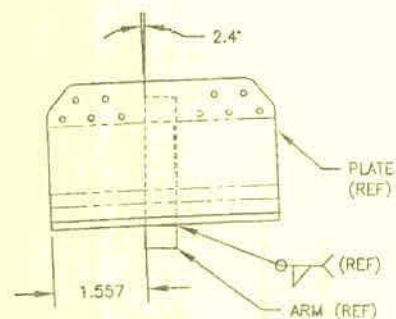
⑤
D3560041
u 07/06/12
①



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 004 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

07 05.07

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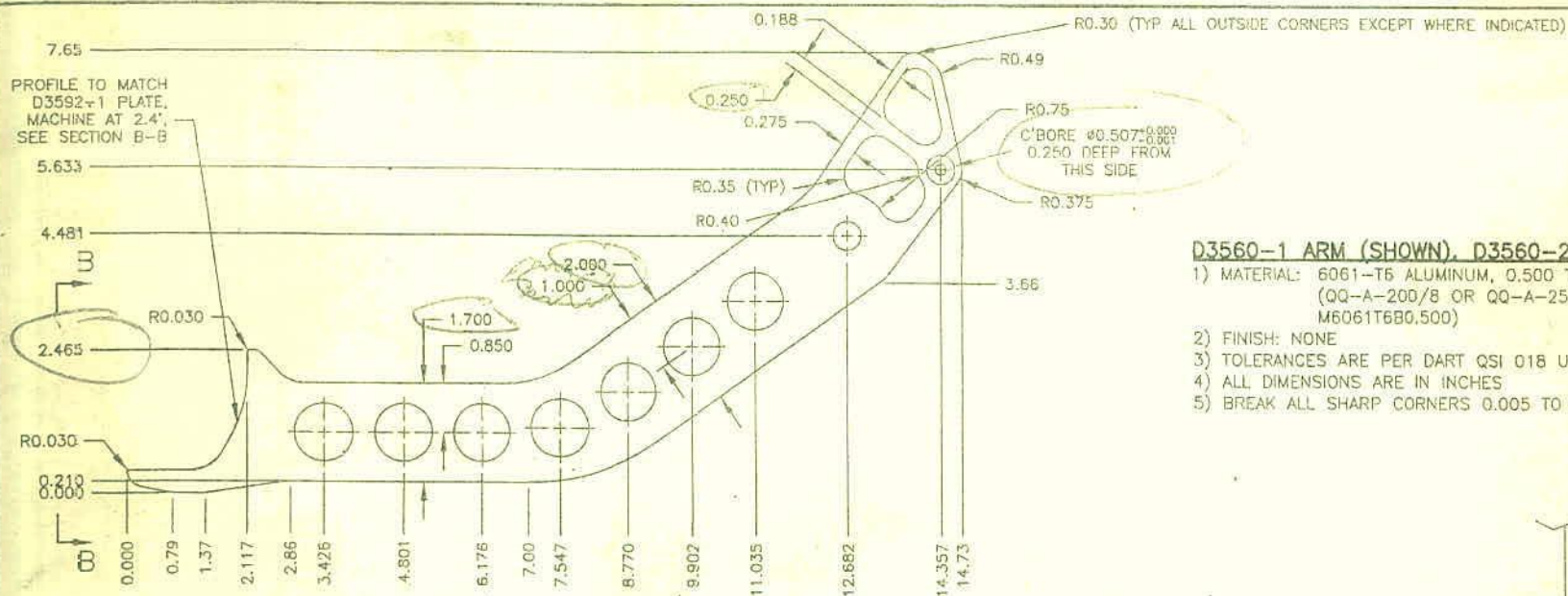
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE
DESIGN	99	DRAWN BY 99
CHECKED	99	APPROVED 99
DATE	07.01.15	TITLE
		ARM WELDMENT

DART DART AEROSPACE LTD.
HARRISBURG, ONTARIO, CANADA

DRAWING NO. D3560
SHEET 1 OF 3

SCALE
1:4

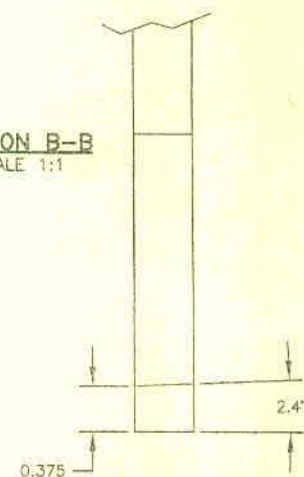
NO. 3264-1
UNCLASSIFIED
DATE 07-05-07



D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B SCALE 1:1



RELEASED

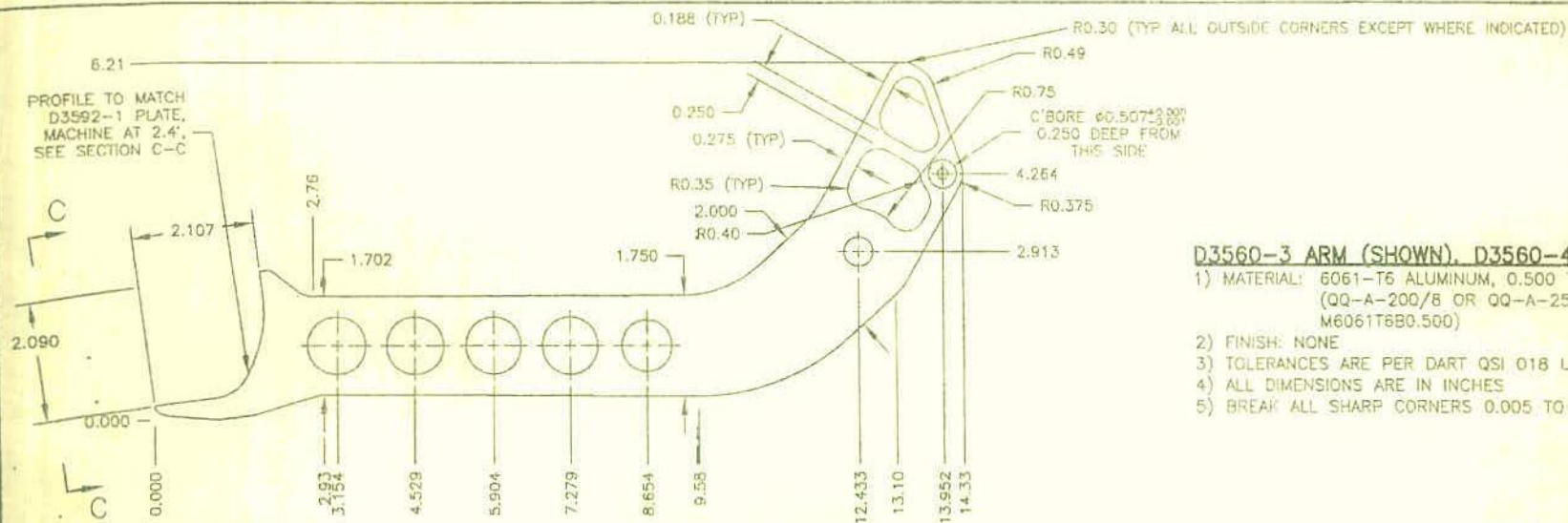
07.05.07 #

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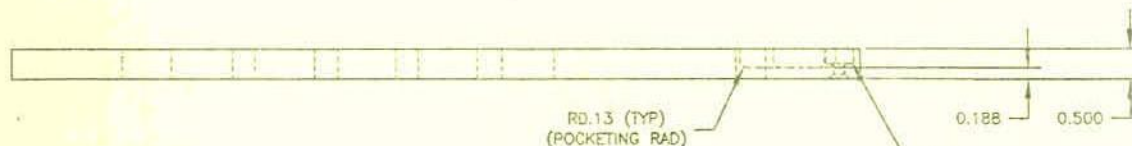
DESIGN	47	DRAWN BY	47	DART	DART AEROSPACE LTD. WILLOWDALE, ONTARIO, CANADA
CHECKED	/	APPROVED	/	DRAWING NO.	D3560
DATE	07.01.15	TITLE	ARM WELDMENT	REV. B	SHEET 2 OF 3
				SCALE	1:2

PROFILE TO MATCH
D3592-1 PLATE,
MACHINE AT 2.4',
SEE SECTION C-C

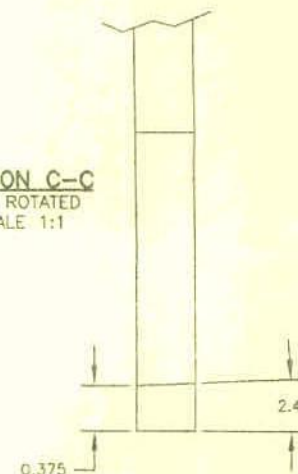


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C
VIEW ROTATED
SCALE 1:1



RELEASE

Ø1.000 THRU
(TYP 4 PLACES)

Ø0.900 THRU
(1 PLACE)

Ø0.196 (DRILL #9 REF)
C'SINK Ø0.385x100'

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DESIGN	q2	DRAWN BY	q2	DART	DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D3560
DATE	07.01.15	TITLE	ARM WELDMENT	REV. 0	SHEET 3 OF 3
				SCALE	1:2

NO. 52643

DART AEROSPACE LTD		Work Order: 32648
Description: A524		Part Number: 03560-1
Inspection Dwg: 03560	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.73	±0.05	14.73	✓			
9.507	±0.002	9.507	✓			
2.50	±0.002	2.50	✓			
1.88	±0.002	1.88	✓			
2.50	±0.002	2.50	✓			
2.25	±0.002	2.25	✓			
2.1465	±0.002	2.1465	✓			
12.682	±0.002	12.682	✓			
14.73	±0.03	14.73	✓			
14.73	±0.002	14.73	✓			
5.633	±0.002	5.633	✓			
1.88	±0.002	1.88	✓			
2.032	±0.002	2.032	✓			
1.500	±0.002	1.500	✓			
9.507	±0.002	9.507	✓			
4.1494	±0.002	4.1494	✓			
3.85	±0.002	3.85	✓			
1.000	±0.002	1.000	✓			
2.000	±0.002	2.000	✓			
1.000	±0.002	1.000	✓			
1.325	±0.002	1.325	✓			
2.13	±0.03	2.13	✓			
1.850	±0.002	1.850	✓			

Measured by: BG	Audited by: JL	Prototype Approval: [Signature]
Date: 07.06.01	Date: 07/06/01	Date: 07.06.01

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: June 5, 2007 5:18 PM
To: 'Chris Provencal'
Subject: RE: D3562-041/-042

As we have discussed previously, this is acceptable as long as the Magnabond doesn't break down.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, June 05, 2007 11:00 AM
To: David Shepherd (David Shepherd)
Subject: D3562-041/-042

David,

For the D3562-041/-042 step weldment, as discussed. They want to switch from Sikaflex to Magnabond, and powder coat after final assembly.

As part of this change, the D3560-XX arms won't be powder coated, and the D2808 Bushing won't be assembled until after final assembly of the step weldment.

Since this is the first time trying this, we will ensure that the steps are checked after powdercoating in case the Magnabond doesn't do anything unexpected (eg. bubbling). If we see anything suspect, we will assemble them the old way.

Is this acceptable.

-Chris

No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.5.472 / Virus Database: 269.8.9/834 - Release Date: 6/5/2007 2:38 PM

